Dart Aerospace Ltd. Monday, 17/07/2006 2:57:26 PM Linda Lacelle **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : JACK SADDLE Customer : 27897 Job Number **Estimate Number** : 11177 : D2281 A14: **Part Number** P.O. Number : 17/07/2006 · D2281 REV G S.O. No. : NIA **Drawing Number** This Issue : N/A Prsht Rev. Project Number : NA : SMALL /MED FAB First Issue **Drawing Revision** : 27897 **Material** : NIA **Previous Run** : 24/07/2006 100 Um: **Due Date** Written By Checked & Approved By Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B waterjet EC 06.07.17 Additional Product Job Number: **Machine Or Operation:** Description: Seq. #: M304S14GA 304SS .080 1.0 Comment: Qty.: 13.1250 sf(s) 0.1313 sf(s)/Unit Total: 304\$\$.080 batch: 410(873 2.0 WATER JET FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: 6 Prog Rev: 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 4.0 SECOND CHECK Comment: SECOND CHECK 5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Each



Comment: Deburr

	day, 17/07/2006 2:57:26 PM la Lacelle	Process Sheet	3	
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: JACK SADDLE		
I.b. Marshari	27007	Dard Name Law D2004		
Job Number: Job Number:		Part Number: D2281		
Seq. #:	Machine Or Operation:	Description :		
6.0	BRAKE NC	NC BRAKE		
Comme	ent: NC BRAKE		SA 2 1-2/20	1
7.0	Form as per D2281 using D2281-T2	INSPECT WORK TO CURRENT STEP	SB 06/08/28	(0
,,,			206.29	
	ent: INSPECT WORK TO CURRENT STEP			
8.0	PACKAGING 1	PACKAGING RESOURCE #1		
Comme	ent: PACKAGING RESOURCE #1	2		
	Identify and Stock Location: <u>US</u> Z	CPC 06.	08-31	
9.0	DC	DOCUMENT CONTROL		
Comme	ent: DOCUMENT CONTROL		The sale	
	Inspection Level 21		POG/09/01	
Job Completion			U des 8/01	
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Thursday, 7/13/2006 3:38:01 PM

User:

Kim Johnston

**Process Sheet** 

05-12-02 JLM

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 27897 : 11177

**Estimate Number** P.O. Number

: 7/13/2006 This Issue

: NC Prsht Rev.

: 11 First Issue

: 26814 **Previous Run** 

Written By

Checked & Approved By Comment

: Est Rev:A

S.O. No. :

Type

Removed from 9 Digit

: SMALL /MED FAB

**Part Number** 

**Drawing Name** 

**Drawing Number** 

**Project Number** 

: D2281 REV G : N/A

: G

: D2281

: JACK SADDLE

Drawing Revision

Material

Due Date

: 8/10/2006

Qty:

100 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

PG

Comment: PURCHASING

Issue P/O:

Email or Ship Dxf file to vendor

Laser cut as per Dwg D2284 Material release note required.

2.0

D2281F

Jack Saddle

**PURCHASING** 



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

100.0000 Each(s)



3.0

PACKAGING 1

PACKAGING RESOURCE #1







Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: Deburr

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	<b>Initial</b> Design Mgr			Section C	Design Mgr	QC Inspector			
06:03:23	2	2 Parts were not in tolerance Because of the waterjet Program "the measurment were not Right" the height and Length of the pay	PSPER CISIONA	Scrap and destroy	5AD 06:08:23	66.48.23	No beg con eng	6 £ 73,			
		·		÷							

Part No:	PAR #:	Fault Category: N	ICR:	Yes (No) DQA:	Date: 06/89/61
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

bate: Thursday, 7/13/2006 3:38:01 PM Úser: Kim Johnston **Process Sheet** Drawing Name: JACK SADDLE Customer: CU-DAR001 Dart Helicopters Services Job Number: 27897 Part Number: D2281 Job Number: Seq. #: Description: **Machine Or Operation:** NC BRAKE BRAKE NC 6.0 Comment: NC BRAKE Form as per D2281 using D2281-T2 INSPECT WORK TO CURRENT STEP 7.0 QC5 WORK TO CURRENT STEP 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion 

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
			:							
NCR:		WORK ORDER NON-C	CONFORMANC	E (NC	R)					

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Varification	Approval Design Mgr					
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Verification Section C		Approval QC Inspector				
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				2								
		-										
				*								

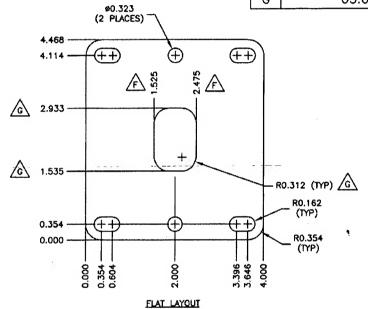
Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: I	N/C C	losed:	Date:	<del></del>

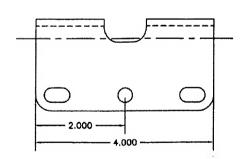


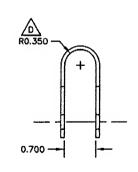
			I THE STATE OF THE
DESIGN BW	DRAWN BY	DART AERO HAWKESBURY, O	
CHECKED	APPROVED	DRAWING NO.	REV. G
$  \psi \rangle$	1111	D2281	SHEET 1 OF 1
DATE	1/2/12	TITLE	SCALE
05.06.07		JACK SADDLE	1:2
A	94.10.14	NEW ISSUE	



	05.0	6.07	JACK SADDLE	1:2
	Α	94.10.14	NEW ISSUE	
ſ	В	94.10.18	DIMENSION WAS 2.878	
	С	94.11.04	ADD TOOLING NOTCH	
	D	98.03.27	R0.350 WAS R0.280	
	E.	04.11.18	REMOVE TOOLING NOTCHES	
	F	05.03.16	REDESIGN FLAT PATTERN	
	G	05.06.07	REDESIGN FLAT PATTERN	







D2281 JACK SADDLE

1), MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)

2) FINISH: NONE

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	27897
Description: JACK SANDLE.	Part Number:	Da2 81
Inspection Dwg: Rev:		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	20.010	4,478	<b>V</b>	1	Vern	
4,114	20.010	4.119			Vern	
2.933	+0.010	2,929	. 1		Vern	
1,535	10.010	1.537			Verin	
0.354	70,016	0.360	. ~	, sec.	Vern	
0.354	20.010	0.352	/		Vern	
0.604	20.010	0,663	1		Vern	
2.000	=0,010	1.998			Vern	
3.396	£0,010	3,3101	/		Vern	
3.646	10,010	3,643	4	ļ	Vern	
4.000	-0.010	4,008			Vern	
1.5 25	=0.010	1.534	/		Vern	•
2,475	10.010	2,478	/	,	Vern	,
¥0.323	40.006/-0.001	\$ 0.323	/		Vern	
0.080.0	+0.010	0.074		y .	Vern	
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		of the state of th				

39					
Measured by:	.SAN	Audited by:	6	Prototype Approval:	MA
Date:	rx6:08:21	Date:	a. 08. 23	Date:	10/17

Rev	Date	Change	Revised by	Approved
A	54.0	New Issue	KJ/JLM	

